

Work Order ID 86414

Thursday, June 28, 2012 11:52:15 AM

86414

Page 1

Item ID: D4418-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Lug

Start Date: 6/28/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/6/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *MC*

Date: *12-06-28*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4418

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 3.125"

OK 12/07/21

8

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB0063

DWG REV: *A*

FOLIO REV: *44*

OK 12/07/22

8

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

DAS
14
2-89 12/07/23

2-7-24

8 16/12-7-24

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

145

Powdercoat

Memo

0.00

Powder Coating

Start Time: 7:30
Temp: 3200F
Finish Time: 8:00

8X ✓

MZ
12/07/25

M121841

146

QC3- Inspect Part Finish

0.00

146

QC

Memo

0.00

Quality Control

8 Ø

B/127.25.

180

Identify as per dwg & Stock Location: ST 481

0.00

180

Packaging

Memo

0.00

Packaging

8X

SP
127.25

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Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/07/25

ME
12-07-25

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Picklist Print

Thursday, June 28, 2012 11:52:14 AM

Page 1

Work Order ID: 86414

Parent Item: D4418-1

Parent Item Name: Step Lug

Start Date: 6/28/2012

Required Date: 7/6/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-12 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.500 6061-T6 Bar 2.00 x 3.50		Purchased	No			100	f	15.8111	0.26	2.1894737			

Location

Loc Qty

Loc Code

MAT009

15.8111

112764

0.7284

118182

11.4527

→ 121660

3.63

2.19 *OK 12/07/21*

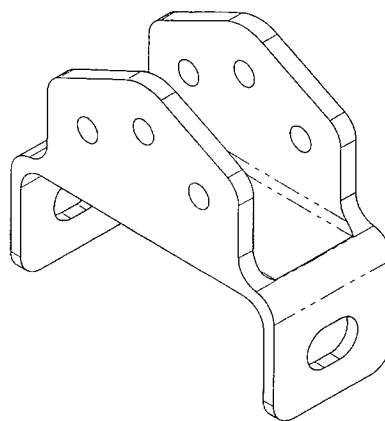
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D4418-1 STEP LUG

#86414

RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4418-1" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.20 lbs

A		NEW ISSUE		AJS		11.07.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		AJS					
CHECKED		[Signature]		DRAWING NO.		REV. A	
MFG APPR.		[Signature]		D4418		SHEET 1 OF 2	
APPROVED		[Signature]		TITLE		SCALE	
DE APPR.		[Signature]		STEP LUG		NTS	
DATE		11.07.04		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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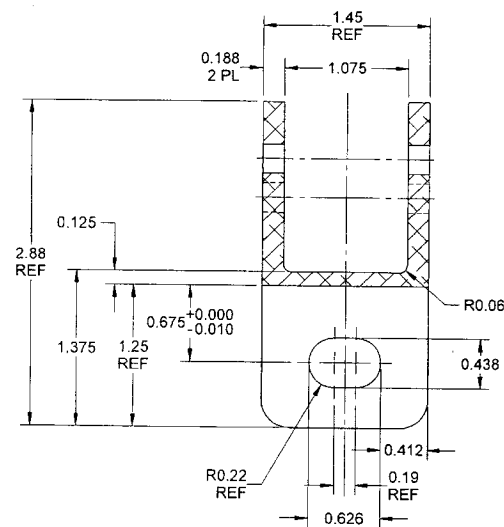
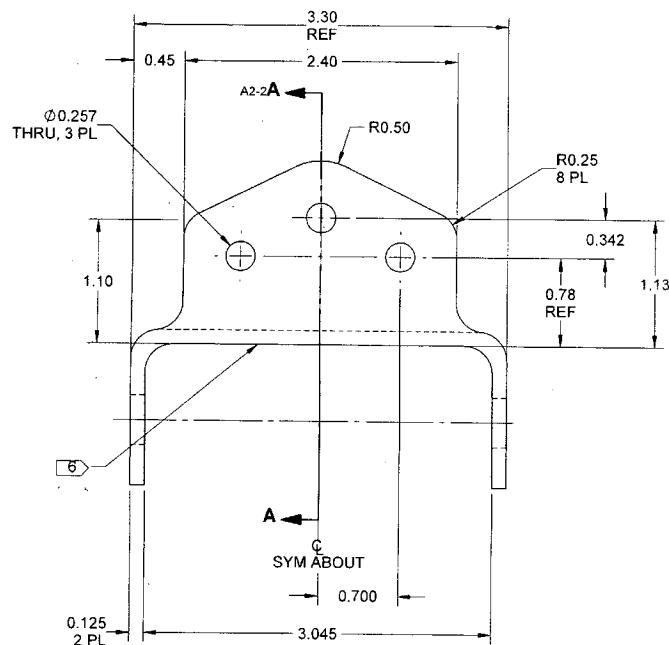
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GRAIN
DIRECTION



SYM ABOUT

SECTION A-A C6-2

RELEASED
2011-07-28

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4418	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP LUG	NTS
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					122		

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